

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004780**Date Inspected:** 10-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG components	

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Part # SP371, DP729.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verification on completed fillet welds made between assembly part number SP371 and DP729 members. The QA Inspector performed the VT and MT verifications on the following identified weld numbers: SP371-001-013 through 024 on inspection part SP371, SP371-001-050 through 061 on inspection part SP371 for the OBG section and DP729-001-001 through 006 on inspection part DP729 for the OBG section. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001386 for additional information. The QA Inspector performed verifications on these welds after ZPMC Quality Control Inspection personnel had completed the VT, MT inspections and reported the welds to be acceptable and ready for the QA Inspector verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during the verifications. The QA Inspector notified ZPMC Quality Control Inspection personnel and Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Part # wsd1-sa107a/j.

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2. The QA Inspector observed ZPMC QC Inspector personnel perform a final VT and MT on the Complete Joint Penetration (CJP) butt splice weld made between flat plates identified as weld number wsd1- sa107a/j - 17a/b for the “lift 1 skin a” section. The ZPMC QC Inspector personnel did not report any welding related discontinuities and did not report any relevant indications during testing. The QC Inspection personnel notified QA Inspector the VT and MT inspections were completed and the weld was reported to be acceptable.

a) At this location the QA Inspector performed a random VT and MT verifications on the CJP butt splice weld identified as weld number wsd1- sa107a/j - 17a/b for the “lift 1 skin a” section. The QA Inspector performed the verifications on this weld after ZPMC Quality Control Inspection personnel completed the VT, MT inspections and reported the weld to be acceptable and ready for verification. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001388 for additional information. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during the verifications. The QA Inspector notified ZPMC Quality Control Inspection personnel and Task Leader Albert Carreon of the observations during verification. Please see the QA Inspector’s Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
